



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2939-1
Job Sheet 180952



Part No: D2939-1

Job Qty: 4 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/31/18	0.00	0.00	Start Up Machining-1		SBCL 16/08/05
100	CNC Vertical Machining	4 pcs		7/31/18	0.50	4.00	HAAS1-2		VH8 18/08/05
110	Mill Conv	4 pcs		7/31/18	0.00	1.87	Mill Conv 1		
120	QC	4 pcs		7/31/18	0.00	0.00	QC1		
130	QC	4 pcs		7/31/18	0.00	0.00	QC8 Machining-1		mmj 16/08/18
140	HandFinish	4 pcs		7/31/18	0.00	0.22	HandFinish1		D.R. 18-08-18
150	Powdercoat	4 pcs		7/31/18	0.00	0.14	Powdercoat1		ell 18-08-18
160	QC	4 pcs		7/31/18	0.00	0.00	QC3		18-08-13
170	Packaging	4 pcs		7/31/18	0.00	0.00	Packaging3-1		57375
180	QC21-SA	4 Ea		7/31/18	0.00	0.00	QC21		AUG 16 2018

Part Op 100 - Program part number and batch number. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & Descriptions: attached Dimension Sheet

110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA015.

150 - START TIME: 7:30am OVEN TEMP: 320°F Fin: 8:00am

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	5038650 5099302

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	77	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval							
Description Work Order Deviation			Disposition								
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S099303 Part: D2939 - 1 Job No: 180952 Serial No/Batch: S099303 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/05/18			Completed By								
			Lead hand / Supervisor Approval Verification								
			QC / QA Coordinator Approval								
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> <tr> <td style="border-right: 1px solid black;"> Misaligned/off center ☐ </td> <td> Misaligned/off center ☐ </td> </tr> </table>			Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Misaligned/off center ☐	Misaligned/off center ☐
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Misaligned/off center ☐	Misaligned/off center ☐										
OTHER : _____											

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.115	0.120	0.118	0.118		
B	0.100	0.140		0.113	0.113	0.116	0.117		
C	0.100	0.140		0.105	0.105	0.103	0.105		
D	0.210	0.230		0.220	0.221	0.221	0.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.257	0.257	0.257	0.257		
L	0.312	0.317		0.312	0.313	0.313	0.313		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.120	0.121	0.121	0.120		
O	0.540	0.560		0.551	0.551	0.551	0.551		
P	0.490	0.510		0.500	0.500	0.502	0.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.249	0.252	0.250	0.250		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DAS	Audited by: <i>[Signature]</i>
Date: 57 9-89 16/08/05	Date: 16/08/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>